

Date: Wednesday, 1/31/2007 2:18:20 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACERS (1/4 THICK)
Job Number : 30543	
Estimate Number : 10247	
P.O. Number : N/A	Part Number : D2022101
This Issue : 1/31/2007 S.O. No. : N/A	Drawing Number : D2022 REV. --
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 27688	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/20/2007 Qty: 400 Um: Each
Checked & Approved By : <u>[Signature] 07.02.01</u>	
Comment : Est D 0203.07 Now made in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0 f(s)/Unit Total : 13 f(s)
6061T6 Round Bar .750"
Material: 6061-T6 (QQ-A-225/8)x.750Ø bar
(M6061T6R0.750 Batch: 403156

2/27 07/02/18

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
1- Note: .257(F) Dia drill
2-Turn Blank as per FolioFA206
3-Tumble & deburr any sharp edges as per dwg

2/27 07/02/18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2/27 07/02/20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2/27 07/02/20 (500)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5

2/27 07/02/20 (500)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACERS (1/4 THICK)

Job Number: 30543

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(500)

Comment: FINAL INSPECTION/W/O RELEASE

SPACERS

Job Completion



U 07-0222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

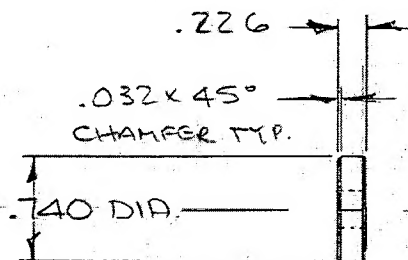
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
970119 BW



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)

NO. 30543
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



D2022

D2022-103		SPACER 5/16	ALUM. 6061-T6	QQ-A-250/B
D2022-101		SPACER 1/4	ALUM. 6061-T6	QQ-A-250/B
PART NO.		ITEM	DESCRIPTION	MATERIAL
CONTRACT NO.		DART AERO ACCESSORIES INC		
DRAWN BRADLEY		DATE 4/10/43	CLIENT	
DESIGN BRADLEY		TITLE SPACERS		
STRESS		CODE	DWG NO. D2022	REV.
CHECKED		SCALE 1:1	SHT 1 OF 1	
CLIENT				

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER HAS 523	QTY. REQUIRED	APPROVAL
DRAWN		BASIC CODE	DIA. DASH NO. H/HEAD REAR SIDE H/HEAD FAR SIDE	
APPROVED		D-DIMPLE D-DIMPLE D-DIMPLE	LENGTH DASH NO. H/SPOTWELD	
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125- 3. REMOVE SHARP EDGES .015 MAX. 4. THICKNESS PER MIL. S. 1742 5. HOLES PER AND 10000 1. TOLERANCES — JIS B 030 2. ANGLES .002 ± .010 3. PARALLELISM .005 4. ECCENTRICITY .005 MAX. 5. SYMMETRY ABOUT ALL H/VC. CENTRE LINES .005	BASIC CODES B/M-25047040 B/M-25047040		
REPORT ALL DISCREPANCIES — DO NOT SCALE				